

Ship Oct. 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:19:08 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASS'Y
Job Number	34827	Part Number	D35313
Estimate Number	12523	Drawing Number	UNDER REVIEW D3531
P.O. Number	N/A	Project Number	N/A
This Issue	9/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	A
First Issue	9/21/2007	Type	SMALL /MED FAB
Previous Run	33301	Material	N/A
Written By		Due Date	10/12/2007
Checked & Approved By		Qty:	5
Comment	Est Rev:A New Issue 06-09.06 EC	Um:	Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.1379 sf(s)/Unit Total : 0.6893 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: m102723 HB07-10-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: A

Prog Rev: A

(5)

2-Deburr if necessary HB07-10-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB07-10-1

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



or as/also counter

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 07-10-02

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSY

Job Number: 34827

Part Number: D35313

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

SB 07/10/05

(5)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/10/05 (+S)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RF 07-10-10 E

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-10

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GIA

MF 07-10-10

(5)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dalila

Job Completion



W 07/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

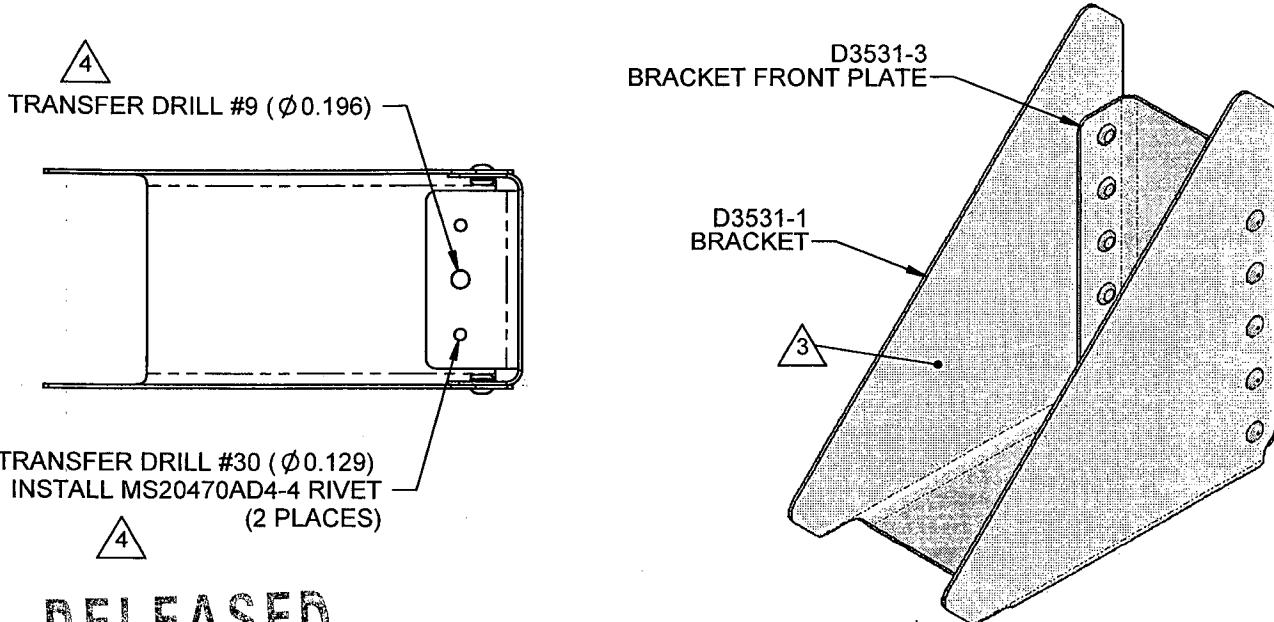
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

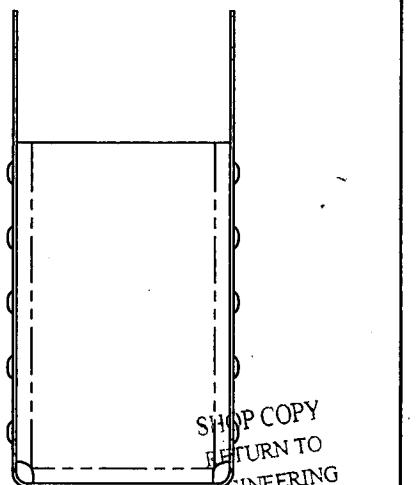
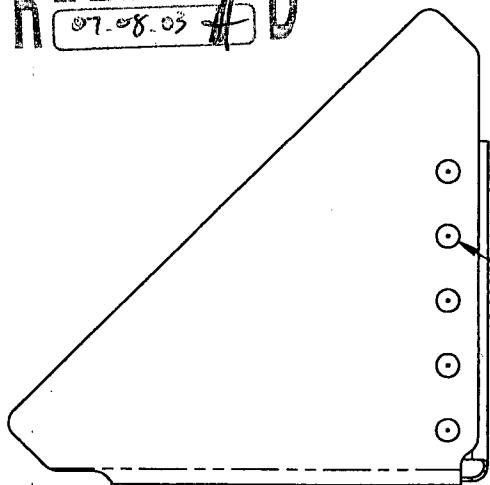
DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>JH</i>	DRAWING NO. D3531
DATE 07.06.19		REV. A SHEET 1 OF 3
		TITLE BRACKET ASSEMBLY

REV	DATE	DESCRIPTION
A	07.06.19	NEW ISSUE



RELEASED
07.08.03



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

PARTS LIST

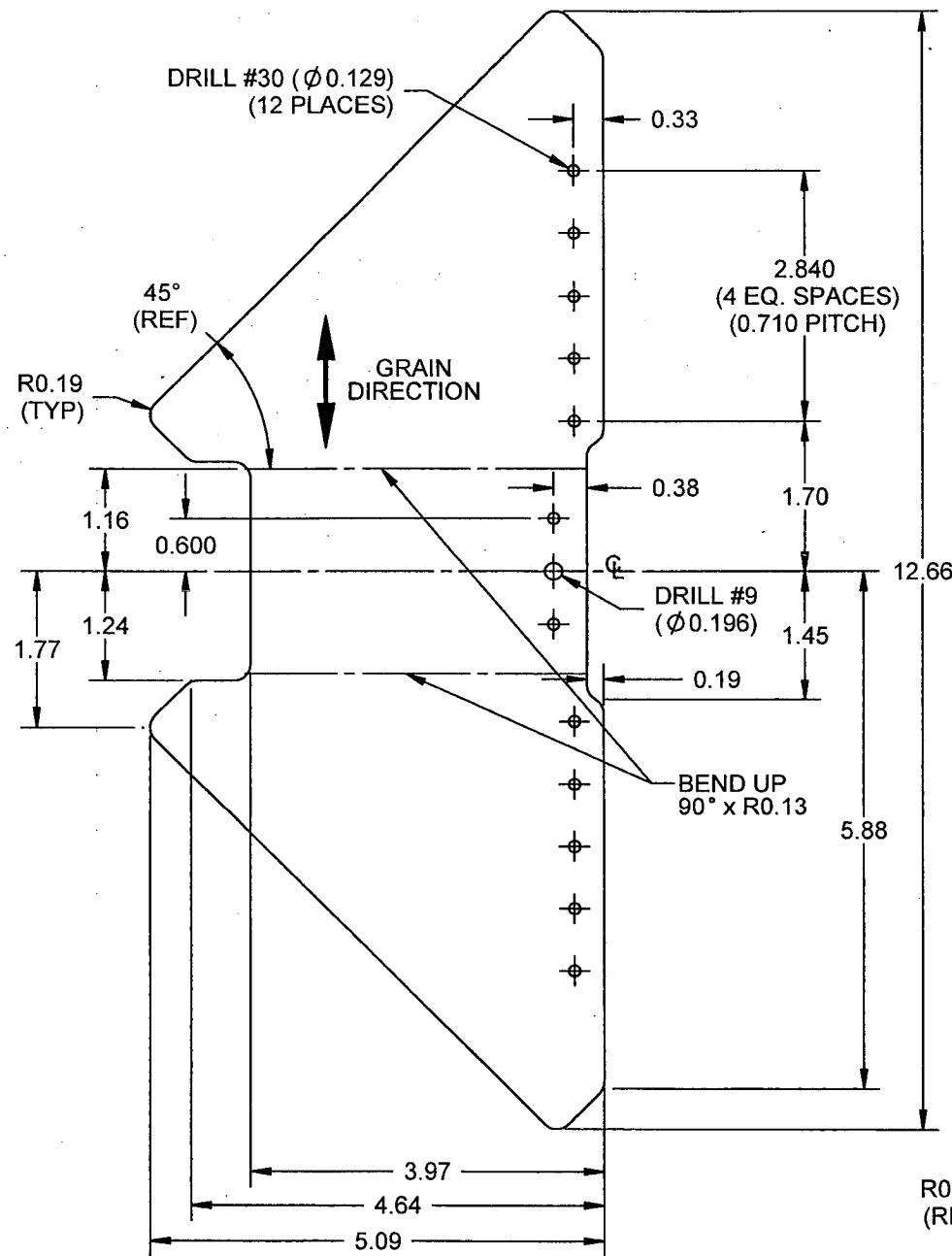
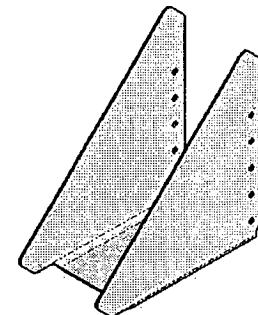
QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>M</i>	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY	SCALE 1:2	



D3531-1F FLAT PATTERN

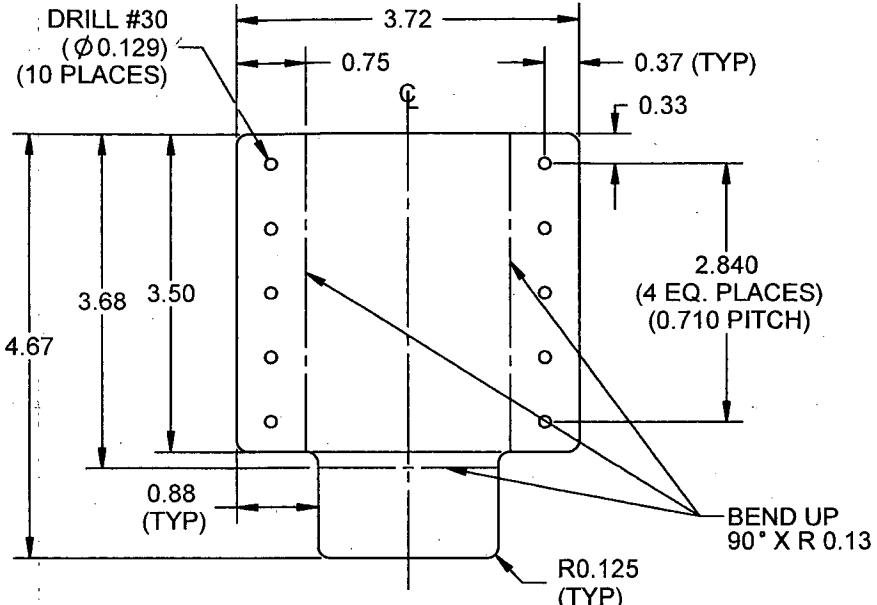
NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT $\frac{1}{4}$

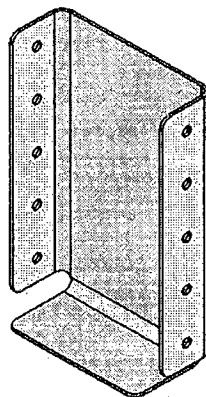
D3531-1 BRACKET
SHOP COPY
REF ID: 10000000000000000000
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3482



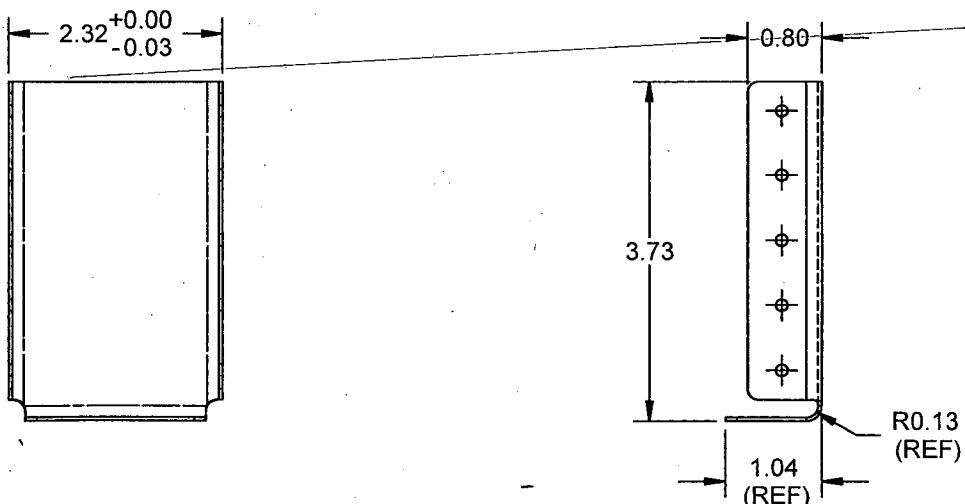
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD	
CHECKED CE	APPROVED H	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY	SCALE 1:2	



RELEASED
07.08.03



D3531-3F FLAT PATTERN



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT $\frac{1}{4}$

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34806

DART AEROSPACE LTD	Work Order:	34827
Description: BRACKET ASS'Y	Part Number:	J3531-3
Inspection Dwg: J353 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>07-10-1</u>	Date: <u>7/10/02</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

4